

Date: Wednesday, 06/09/2006 11:05:08 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GPS RECEIVER HOUSING
Job Number	: 28419	Part Number	: D35147
Estimate Number	: 12494	Drawing Number	: UNDER REVIEW <i>E 06.09.05</i>
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 06/09/2006 S.O. No. : N/A	Drawing Revision	: N/A
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 13/09/2006
Previous Run	: N/A	Qty:	1 Um: Each
Written By	: <i>E</i>		
Checked & Approved By	: _____		
Comment	: Est Rev:A New Issue 06-07-26 JLM		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.2518 sf(s)/Unit Total : 0.2518 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *MTS 380**MM 06 09 07*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3514

Dwg Rev: *Pre*Prog Rev: *Pre**MM 06 09 07**(1)*

\*\*\*Ensure Grain Direction is correct\*\*\*\*\*

2-Deburr if necessary

*MM 06 09 07**(1)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MM 06 09 07**(1)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*SD 06.09.07**(1)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/07/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:09 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS RECEIVER HOUSING

Job Number: 28419

Part Number: D35147

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form Joggle as per Dwg D3514

SB 06/09/07

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 06-07-07 ①

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

A.M. 06-09-06-09-12

①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JB 06-09-12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock For Eng. use only

Location: \_\_\_\_\_

JB 06-07-19

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

JB 07-07-24

Job Completion



u 06-09-20

Eng Approval

CB 07.03.08

PART NOT MARKED AS PROTOTYPE. PART WENT TO HAI.  
PART IS NOT APPROVED AND NOT AIRWORTHY

CB 07.07.13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

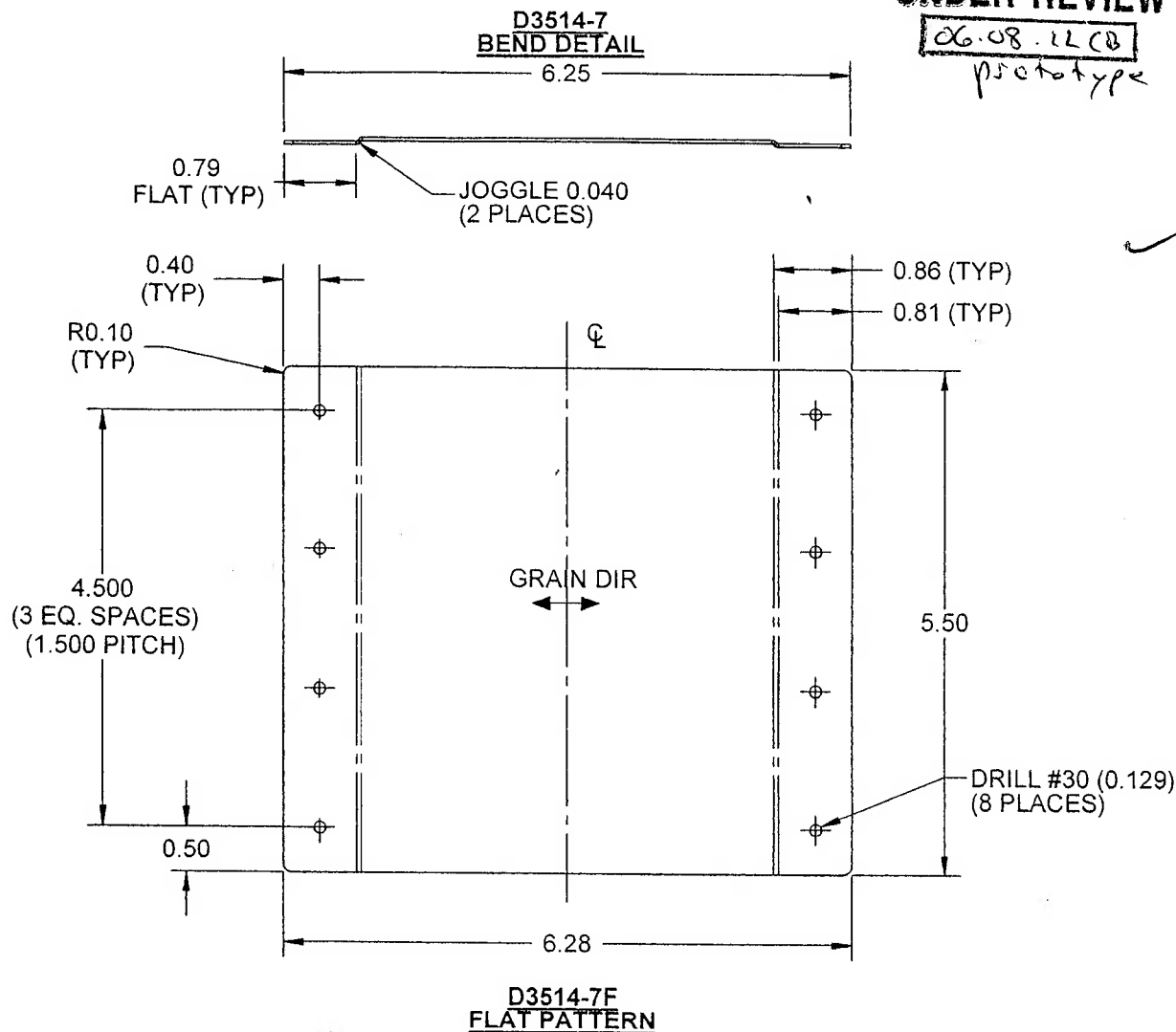
NOTE: Date & initial all entries

# PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3514	REV. A
DATE 06.05.03		TITLE GPS RECEIVER HOUSING	SHEET 6 OF 7
			SCALE 1:2

**UNDER REVIEW**

06.08.12 CB  
prototype



## D3514-7 BOX BOTTOM (TOP MOUNTED)

### NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040" SHEET  
(REF: DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT  $\phi$

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DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 1

KEURINGSRAPPORT



KLANT : COPPER AND BRASS SALES  
CORPORATE SERVICES DIVISION  
SOUTHFIELD, MI USA

Corus Aluminium N.V.  
A. Stodelaan 87, 2570 Duffel - Belgium  
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)  
ONS ORDERNUMMER : 58848/01  
DOCUMENT NUMMER : V/0080151422

SPECIFICATIES: ALU SHEETS (STENC.) AA 5061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04  
AFMETINGEN : 144" X 48" X 0.04"  
ARTIKEL NR. :

ROL- NUMMER		GEUT- NUMMER		CHEMISCHE ANALYSE (%)						
		MIN	SI 0,40	FE 0,7	CU 0,15 0,40	MN 0,15	MG 0,8 1,2	CR 0,04 0,35	TI 0,15	ZN 0,25
001	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01
002	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,02	0,01
ANDERE : ELK				:	MIN	0,05 MAX				
TOTAAL				:	MIN	0,15 MAX				

TEST- NUMMER		MECHANISCHE EIGENSCHAPPEN				
		1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI				
		/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM				
		MIN	MAX	RM KSI	RP02 KSI	A %
				42	35	10
001	/A			47	39	16
001	/M			47	39	15
001	/V			47	39	16
002	/A			47	39	16
002	/M			48	40	16
002	/V			48	39	16

COPPER AND BRASS SALES  
SOLD TO: 0 73

M/19380

COPPER AND BRASS SALES

SOLD TO: C & BDATE: 12/16 QTY. 20CUSTOMER PO: 00000024SHIPPER NO: 4V3128BY: 8

Corus Aluminium Rolled Products - Corus Aluminium Extrusions